



Chandrabrabhu **E**nterprise **P**rivate **L**imited

HARDFACING WELDING WIRES

Name: CEPL-DOHN

Weld metal chemistry	C = 0.03%, Cr = 12.80%, V = 0.50%, N = 0.13%, Ni = 5.00%, W = 0.80%, Mn = 1.20%, Mo = 0.60%, Si = 0.60%, Co = 2.00%	
Hardness (3 layers)	43–48 HRC	
Size	1.60mm, 2.00mm, 2.40mm and 2.80mm	
Welding parameter guidelines (with CO₂ shield)	Size	Range
	1.6mm	150–300A, 25–28V
	2.0mm	200–350A, 26–28V
	2.40mm	250–450A, 27–29V
	2.80mm	300–450A, 27–30V
Wire extension (stickout)	30–35mm	